



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-705-013
Job Sheet 178728



Part No: D412-705-013

Job Qty: 1 ea

Part Name: Intake Plenum Access Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/6/18

Job Tracking No:

Due Date: 6/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEET 18 IPP Rev:A New Issue 07-09-09 JLM Verified By:EC IPP Rev:B ECN 1052 07-11-05
DD Verified by:EC IPP Rev:C ECN 12-670 12.11.07 DD Verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/27/18	6/27/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 18 2018
110	Packaging	1 pcs	6/27/18	6/27/18	0.00	0.00	Packaging1-4		JUN 19 2018
120	QC	1 pcs	6/27/18	6/27/18	0.00	0.00	QC4		JUN 28 2018
130	Packaging	1 pcs	6/27/18	6/27/18	0.00	0.00	Packaging3-2		JUN 28 2018
135	DC	1 pcs	6/27/18	6/27/18	0.00	0.00	DC		JUN 22 2018
140	QC21-FG	1 Ea	6/27/18	6/27/18	0.00	0.00	QC21		JUN 22 2018

Part Op 130 - Identify and pack for shipping as per PPP D412-705-013 Location : FG027
Descriptions: 135 - Photocopy bluefile & type labels per PPP D412-705-013 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3245-041	Access Panel Assembly LH	1 Ea (1 ea)	90-Start up Operation	S055248
D3245-042	Access Panel Assembly RH	1 Ea (1 ea)	90-Start up Operation	S082068
D3245-043	Door Assembly	2 Ea (2 ea)	90-Start up Operation	S054949
D3245-11	Gasket 9.01	2 Ea (2 ea)	90-Start up Operation	S046777
D3245-13	Gasket 9.50	2 Ea (2 ea)	90-Start up Operation	S035644
D3245-9	Gasket 8.35	2 Ea (2 ea)	90-Start up Operation	S046783
MS20427M3-3	Rivet	16 Ea (16 ea)	90-Start up Operation	Pm136741-4
MS21060-L3K	Nut Plate	8 Ea (8 ea)	90-Start up Operation	S0168810

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3245-041	1	1	0
	D3245-042	1	0	0
	D3245-043	2	9	0
	D3245-11	2	6	0
	D3245-13	2	13	0
	D3245-9	2	6	0
	MS20427M3-3	16	869	0
	MS21060-L3K	8	56	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Container No: S081770 Part: D412-705-013 Job No: 178728 Serial No/Batch: S081770 Revision: F Inspector: Exp Date: Instructions:

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folic ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grai ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Wel ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wri ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Ou ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mi ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Mi ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

Date: 06/16/18

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Specifications could not be found.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003923	S055248	D3245-041	Access Panel Assembly LH	S055246	ST488	1
003923	S081757	D3245-043	Door Assembly	s054944	ST488	2
003923	S081758	D3245-11	Gasket 9.01	s046777	ST027	2
003923	S081759	D3245-13	Gasket 9.50	s030644	ST028	2
003923	S081760	D3245-9	Gasket 8.35	s046783	ST027	2
003923	S081762	MS20427M3-3	Rivet	fm136741-4	ST311	16
003923	S081764	MS21060-L3K	Nut Plate	s016886	GA012	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/18/18 9:02 AM dart.quirion.sonia

REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.

REFERENCE ONLY